

Date: Tuesday, 7/1/2008 2:35:10 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : MOUNTING LUG

Job Number : 40200

Estimate Number : 11539

P.O. Number

This Issue : 7/1/2008

S.O. No. :

Prsht Rev. : NC

First Issue : 1/1

Type : MACHINED PARTS

Previous Run : 28522

Part Number : D30521

Drawing Number : D3052 REV B

Project Number : N/A

Drawing Revision : B

Material

Due Date : 7/11/2008

Qty:

37

20 Um:

Each

Written By

Checked & Approved By

Comment

Est.A 02.01.28 New Issue NG

Est.B Rev.B dwg 07-09-25 DD verified by EC

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B1000X04000

6061-T6 Bar 1.0" x 4.0"

Comment: Qty.: 0.2625 f(s)/Unit Total: 5.2500 f(s)

6061-T6 Bar 1.0" x 4.0"

Material: 6061-T6 aluminum bar 4" X 1" thick

Batch: M11941 ⇒ 14 blanks

M107221 ⇒ 6 blanks

SD 08/10/09

2.0

BAND SAW

BAND SAW

Comment: BAND SAW

Cut blanks: 5,600" long

SD 08/10/09

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA184

Tumble & Deburr

SD / H.A

37

08/07/11

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD / H.A

37

08/07/11

5.0

QC8

SECOND CHECK

Comment: SECOND CHECK

37

SD 08/02/12

37

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3052-1 PAR #: N/A Fault Category: Prod / Machine ^{Parts} NCR: Yes No DQA: 1 Date: 28/07/29
 QA: N/C Closed: 1 Date: 28/07/29

NCR: <u>40200</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/15	# 30	when operation entered in for first shift it was noticed that the first part was machine incorrectly	<u>Rosier</u>	Scrap and Destroy and Replace QTY <u>10</u> <u>B# M10721</u>	<u>91</u>	<u>08/07/17</u>	<u>Rosier</u>	<u>08/07/15</u>
		Both bars were made on same area location R.C. operator error / did not flip his part for the 2nd operation.	<u>Rosier</u>		<u>SA</u> <u>08/07/17</u>	<u>08/07/17</u>	<u>Rosier</u>	<u>08/07/15</u>
8/7/15	# 30	after first part was complete it was noticed by operator that the 9.8 mm Drill was not be deep enough. when he tried to fix error he drill a chamber on other side R.C. operator error.	<u>Rosier</u>	Scrap Destroy and no replace Replace QTY 10 <u>B#</u>	<u>N.A</u> <u>09/07/16</u>	<u>08/07/17</u>	<u>Rosier</u>	<u>08/07/15</u>

NOTE: Date & initial all entries on other side

Date: Tuesday, 7/1/2008 2:35:10 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 40200

Part Number: D30521

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. 08/07/17

(37)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*****mask slot as per dwg*****

M 108523

(37X)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*8:55
320°
9:25*

M. 08/07/21

(P15)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

08/07/08

(37)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

52472

08/11/22

(37)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/23

Job Completion



MF 08-07-22

Dart Aerospace Ltd

W/O: 40200		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

2-NCR's

Part No: D3052-1 PAR #: _____ Unit Category: Prod/Finishing NCR: Yes ☒ No ☐ DQA: D Date: 08/07/21
QA: N/C Closed: D Date: 08/07/21

NCR: 40200		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/21	70	During QC3 Powder coat inspection it was noticed that only one side was at the inside channel was tape off.	[Signature]	Remove Powder coat in areas where powder coat doesn't belong sand blast	[Signature] 08/07/21	[Signature]	[Signature]	[Signature]
		QC employee for missed tapping the base and one side	[Signature]	Re admin. n as per QS 7005 inspect by QC	[Signature] 08/07/21	[Signature]	[Signature]	[Signature]
			[Signature]	Re powder coat if needed as per QS 7005	[Signature] 08/07/21	[Signature]	[Signature]	[Signature]

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	40200
Description: Mounting Lug		Part Number:	D3052-1
Inspection Dwg: D3052 Rev: A		Page 1 of 1	

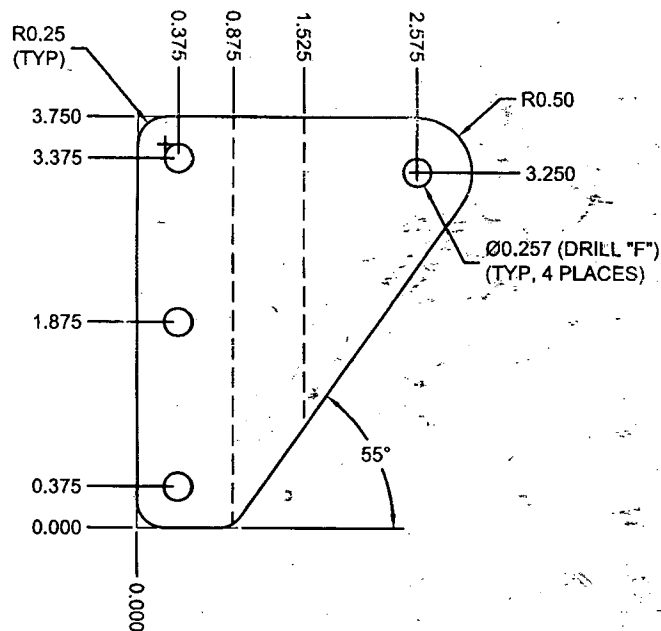
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.250	+/-0.010	R0.250	✓			
0.375	+/-0.010	0.375	✓			
0.875	+/-0.010	0.880	✓			
1.525	+/-0.010	1.523	✓			
2.575	+/-0.010	2.571				
R0.500	+/-0.010	R0.500	✓			
3.250	+/-0.010	3.244	✓			
Ø0.257	+0.006/-0.001	Ø0.260	✓			
0.375	+/-0.010	0.3695	✓			
1.875	+/-0.010	1.869	✓			
3.375	+/-0.010	3.370	✓			
3.750	+/-0.010	3.745	✓			
0.115	+/-0.010	0.109	✓			
3.075	+/-0.010	3.077	✓			
R0.06	+/-0.030	R0.06	✓			
0.500	+/-0.010	0.503	✓			
0.250	+/-0.010	0.242	✓			
0.770	+/-0.010	0.771	✓			
1.000	+/-0.010	0.993	✓			
3.750	+/-0.010	3.747	✓			
Ø0.386	+0.006/-0.001	Ø0.388	✓			

Measured by:	M.A	Audited by:	DJP	Prototype Approval:	N/A
Date:	08/07/11	Date:	08/07/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.05	New Issue	KJ/JLM	BE



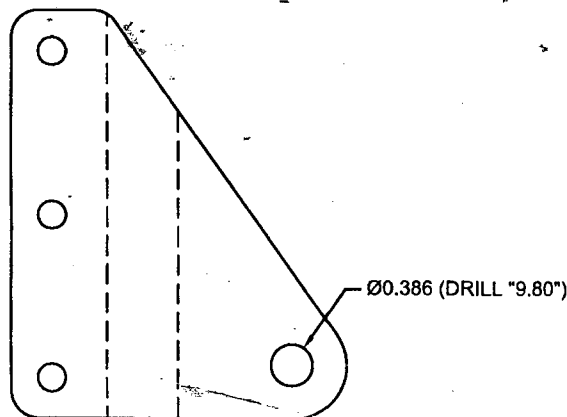
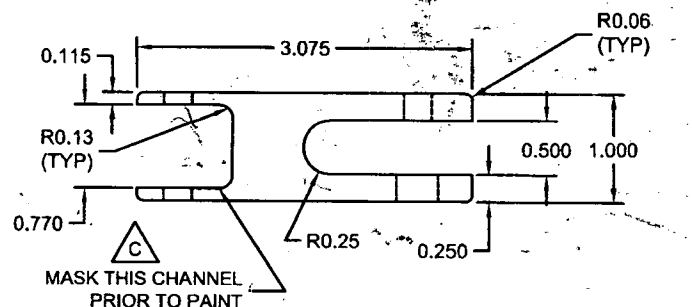
RELEASED

07.08.29

D3052-1 MOUNTING LUG

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3052-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.44 lbs



B	- ADDED MASKING DETAIL - DUE TO TIGHT FIT WHEN INSTALLED ON BASKET - ADD MASKING STEP TO ESTIMATE	DC	07.07.25
A	NEW ISSUE	RF	01.11.01
REV.	DESCRIPTION	BY	DATE
DESIGN	JE DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	JE DC	DRAWING NO.	REV. B
MFG. APPR.		D3052	SHEET 1 OF 1
APPROVED	JE DC	TITLE	SCALE
DE APPR.		MOUNTING LUG	1:2
DATE	07.07.25	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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NO. 40200

